Wո	rk	Ord	ler	ID	73298
* * * * * * * * * * * * * * * * * * * *		.,			12470



Page 1

Wednesday, August 31, 2011 10:45:33 AM Item ID: D3413-1 Accept Setup Start **Revision ID:** Stop Item Name: Ring **Start Qty: 20.00 Start Date:** 9/1/2011 **Cust Item ID:** Req'd Qty: 20.00 Required Date: 9/15/2011 **Customer:** Reference: Run Start Process Plan: Date: Approvals: **Tooling:** Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID Description Code Qty Qty Number Stamp **Run Hours** Draw Nbr **Revision Nbr** . D3413 Rev A 100 0.00 FLOW WATER JET Waterjet 0.00 Memo FLOW CNC Wateriet 1-Cut as per Dwg D3413 Dwg Rev: A 364 ,756× 4 Prog Rev: 2-Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 QC 0.00 Memo Quality Control 120 QC8- Inspect parts - second check Memo Quality Control

Dart Aei	rospace	e Lta							. т .
W/O:		,	W	ORK ORDER CHANGE	S				
DATE	STEP	PROC	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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									·
Part No	:	PAR #:	_ Fault Cat	degory:	NCR: Yes	s No DQ	A:	Date: _	· · · · · · · · · · · · · · · · · · ·
	R	esolution:	ion:	QA: N/C Closed:				·	
NCR:		W	ORK ORI	DER NON-CONFORMA	NCE (NC	R)			
		Description of NC		Corrective Action Section	n B	Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Dat	& Sect	ion C	Chief Eng	QC Inspector
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Work Order ID 73298

Wednesday, August 31, 2011 10:45:33 AM



Page 2

Item ID:

D3413-1

Accept

Setup Start

Stop

Revision ID:

Item Name: **Start Date:**

Ring

Required Date: 9/15/2011

9/1/2011

Start Oty: 20.00

Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start Run

OC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/

Work Center ID

Operation **Description** Set Up/ **Run Hours** Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

130

Small Fab

Small Fab

Small Fab

Memo

Memo

0.00

1- Deburr and drill hole if required as per dwg D3413 & QSI018 4.1.

140

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Dulodi 3

150

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

START TIME:

HOU OF FINISH TIME:

Qux & M-fulou/14

W118439

									t •
W/O:			V	VORK ORDER CHANG	By Date Qty Approval Chief Eng / Prod Mgr QC Inspector NCR: Yes No DQA: Date: QA: N/C Closed: Date: ONFORMANCE (NCR) Ction Section B Verification Section C Section C Chief Eng QC Inspector				
DATE	STEP	PRO	CEDURE CH	IANGE	Ву	Date	Qty	Chief Eng /	
DATE STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr Part No: PAR #: Fault Category: NCR: Yes No DQA: Date: Resolution: Disposition: QA: N/C Closed: Date: NCR: WORK ORDER NON-CONFORMANCE (NCR) DATE STEP Description of NC	Date: _								
	R	esolution:	Disposit	tion:	_ QA: N/C	Closed:		Date:	
NCR:		V	VORK OR	DER NON-CONFORMA	ANCE (N	CR)			
DATE	STEP			Action Description	Sig	ın & s			
			Chief Eng	Chief Eng		ate			
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Work Order ID 73298

Page 3

Item ID:

Wednesday, August 31, 2011 10:45:33 AM D3413-1

Accept

Setup Start

Stop



Revision ID:

Item Name: **Start Date:**

Ring

Required Date: 9/15/2011

9/1/2011

Start Qty: 20.00

Req'd Qty: 20.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop

Date: _____

SPC (Y/N):

Set Up/

Run Hours

Date:

Accept

Reject

Reject

Bl 11-9-15

Insp.

Work Center ID

160

Sequence ID/

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

0.00

0.00

Tool ID

Tool # Plan

Code

Qty

Qty

Number

Stamp

170

Packaging

Packaging

Identify as per dwg & Stock Location: ST HG

Memo

0.00

0.00

180

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Dart Ae	rospace	e Ltd							,
W/O:			W	ORK ORDER CHANGE	S				*
DATE	STEP	PRC	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A:	Date: _	
	Resolution:		Disposition	on:	QA: N/C C	osed:		Date: _	
NCR:	14	1	WORK ORD	ER NON-CONFORMAL	NCE (NCF	R)			
		Description of NC	Corrective Action Se		ction B		cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	1. 1	ion C	Chief Eng	QC Inspector
		,							

Picklist Print

Wednesday, August 31, 2011 10:45:29 AM

Work Order ID: 73298

Parent Item: D3413-1

Parent Item Name: Ring



Start Date: 9/1/2011

Required Date: 9/15/2011

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP Rev:A□05.09.13□New issue□KJ/JLM IPP Rev:B Now on Waterjet 07-05-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250X4.000		Purchased	No			100	f	18.5000	0.25	5.263158			
										1	B11-9-	٦	

304 BAR .250 x 4.00

Location	Loc Qty	Loc Code
MAT009	18.5	
118182	18.5	



Duit Au	Johade	, E.u							,
W/O:			WC	RK ORDER CHANGI	ES	, -			
DATE	STEP	PROC	EDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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							,		
Part No	:	PAR #:	_ Fault Cate	gory:	NCR: Yes	No DQA:		_ Date: _	
	R	esolution:	_ Dispositio	າ:	_ QA: N/C Cld	sed:		Date: _	
NCR:	٠.	W	ORK ORDI	ER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	on B Sign & Date	Verifica Section		Approval Chief Eng	Approval QC Inspector

DART AEROSPACE LTD	Work Order:	
Description: Ring	Part Number:	D3413-1
Inspection Dwg: D3413 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.88	+/-0.030	728,8	×		V BOZ	
Ø2.00	+0.012/-0.001	7.08	>		V	
0.75	+/-0.030	.751	x		V	
Ø0.266	+0.006/-0.001	८२८,	8		V	
0.250	+/-0.010	126,	カ		V	

Measured by:	Audited by: 🖔	Prototype Approval: N/A	
Date: 11-9-7	Date: 11/67/13	Date: N/A	
D. D. L. Ohanna			

Rev	Date	Change	Revised by	Approved
Α	07.09.06	New Issue	KJ/JLM ox	E
			- '()	

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
		•									
				·							

Part No:		_ PAR #:	Fault Category:	NCR: Yes No DQA:	Date:	
			•		•	
	Resolution:	_	Disposition:	QA: N/C Closed:	Date:	

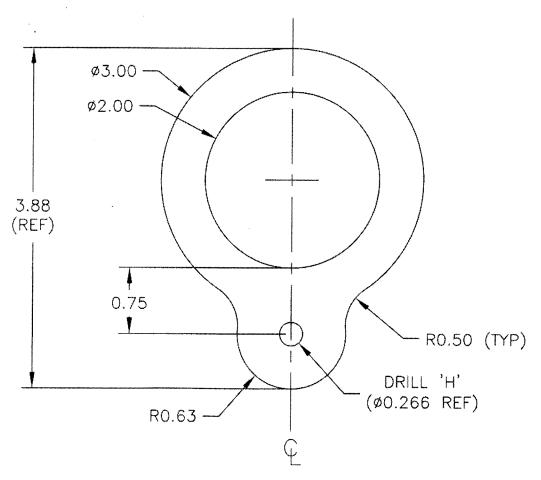
	WORK ORDER NON-CONFORMANCE (NCR)									
	P Description of NC Section A	Corrective Action Section B			Verification	Approval	Annroyal			
STEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector			
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	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Corrective Action Section B Initial Action Description Sign &	STEP Description of NC Corrective Action Section B Verification Section C	STEP Description of NC Section A Chief Eng Chi			

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE



DESIGN (CP	DRAWN BY	DART	AEROSPACE PORT HADLOCK, I		INC.
CHECKED "	册	APPROVED A	DRAWING NO.		SH	REV. A
DATE	<u>`</u>	L	TITLE	**************************************		SCALE
 05.03.1	16		RING			1:1
Α		05.03.16	NEW ISSU	JE		





D3413-1 RING

- 1) MATERIAL: AISI 304/316 SS PLATE, 0.250 THICK (REF DART SPEC. M304S3GA)
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) DEBURR ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	ROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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	-									
5			-		NOD V	N. 54		D-4	J	
		PAR #:								
Resolution			.,			PA: N/C Closed: Date:				
NCR:		1	WORK ORI	DER NON-CONFORMA	ANCE (NC	R)				
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification		1 Approval	Approval	
DATE			Initial Chief Eng	Action Description Chief Eng	Sign Dat		ction C	Chief Eng	QC Inspector	
}										
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		·								